

## Work Order ID 57226

March 30, 2010 11:31:28 AM



Page 1

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 30/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 08/04/2010 Req'd Qty: 10.00



Customer:

Reference:

JJP 10-03-30

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	--	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3571	Rev A

100 0.00



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank 2.90 " long

DJP 10/03/30 10 Ø

110 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

HAAS CNC vertical machine #1

I- Mill as per Folio FA675 Rev: AA & Dwg D3571 Rev: A 2-Deburr  
per dwg D3571

MW= 10/04/06

10 Ø

120 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

MW= 10/04/06

10 Ø



# Work Order ID 57226

March 30, 2010 11:31:28 AM



Page 2

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 30/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 08/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

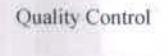
Operation  
Description

130



QC8- Inspect parts - second check

QC



Quality Control

140



Chemical Conversion Coat per QSI005 4.1

HandFinish

Hand Finishing

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Powder Coating

Memo

START TIME:  
2:15pm FINISH TIME:  
1:45pm

0.00

0.00

OVEN TEMPERATURE:  
320°F

Set Up/  
Run Hours  
0.00  
B.A 10/04/07

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

10 ✓

x10 ✓

(x10) ✓



**Work Order ID 57226**

March 30, 2010 11:31:28 AM



Page 3

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 30/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 08/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

160



QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

BL 10-4-8 ⑩

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 248A

0.00

0.00

PCK/4/19/C

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/04/12 AD  
MF 10-4-9



# Picklist Print

March 30, 2010 11:31:28 AM

Page 1  
T

Work Order ID: 57226



Parent Item: D3571-1



Parent Item Name: Guide

Start Date: 30/03/2010

Required Date: 08/04/2010

Comments: IPP Rev:A New Issue 07-02-01 JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	6.2559	2.5368			

6061-T6 Bar .750 X 1.50

Jnl 10.03.30  
100 Batch L 07/11  
6061-T6 Bar .750 X 2,000  
M 111448

Warehouse	Loc Qty	Loc Code
Main Warehouse		
MAT02	6.25589949	
110167	6.25589949	

2.5368(f) DIP 10/3/30



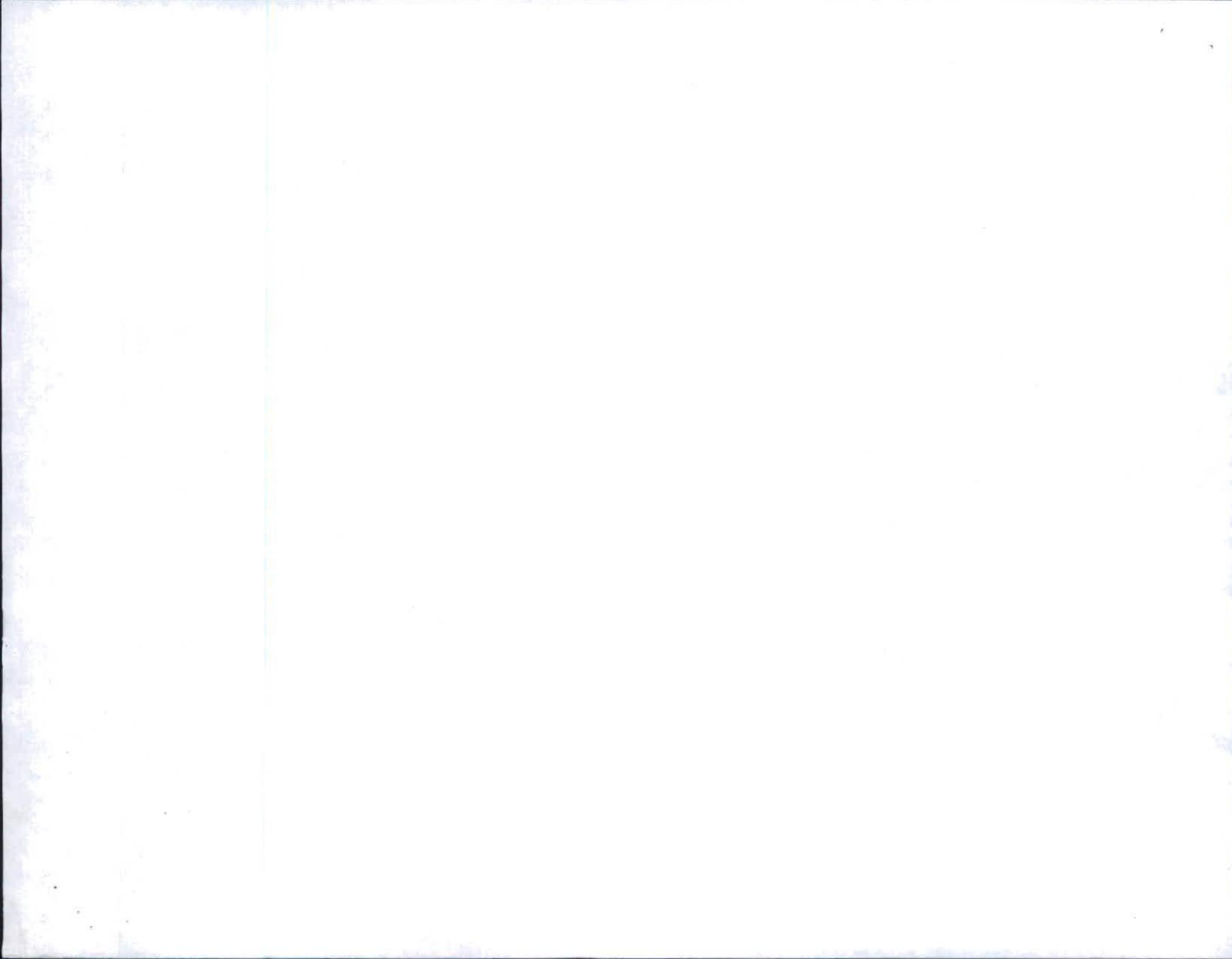
DART AEROSPACE LTD	Work Order:
Description: Guide	Part Number: D3571-1
Inspection Dwg: D3571 Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	MW	Audited by:	H.A.	Prototype Approval:	N/A
Date:	10/04/06	Date:	10/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	[Signature]



**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571
DATE 07.01.29		TITLE GUIDE

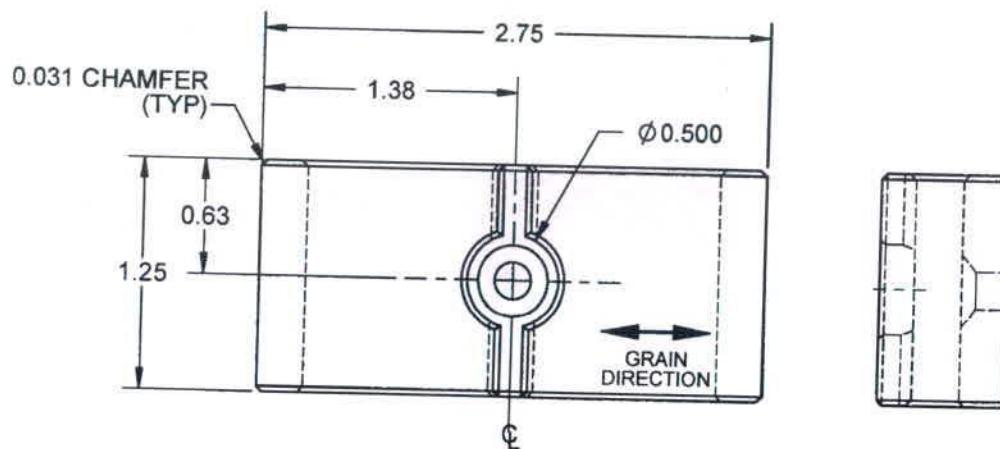
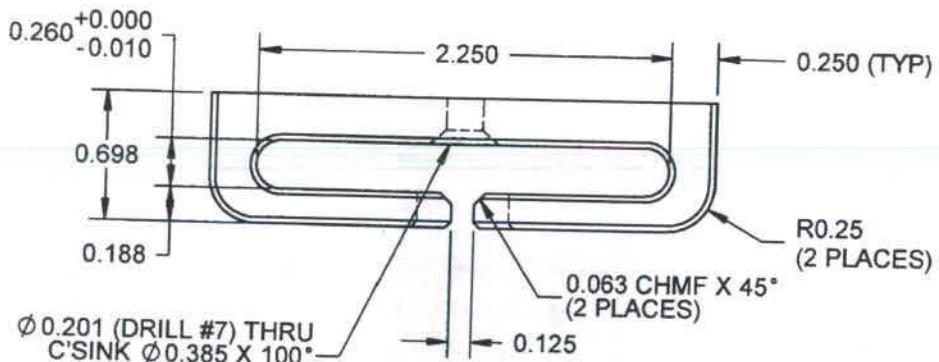
REV. A

SHEET 2 OF 2

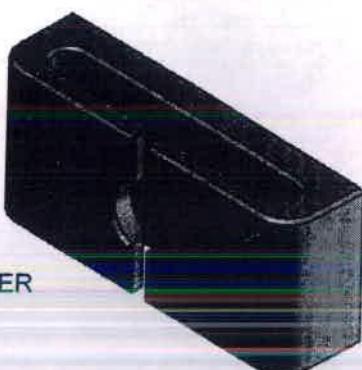
SCALE

1:1

RELEASED

07.04.12 *[Signature]***D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\text{C}$

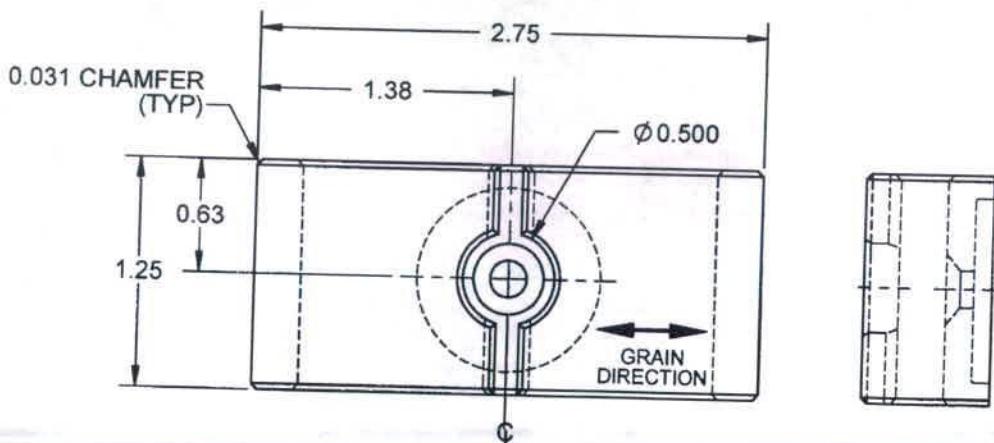
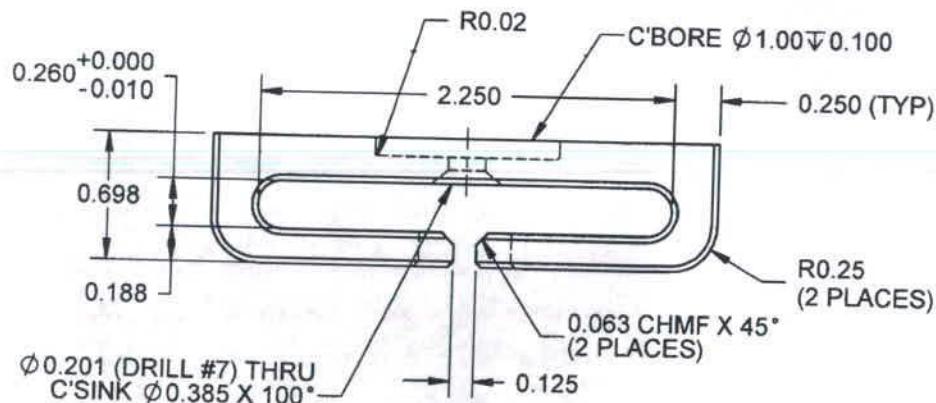
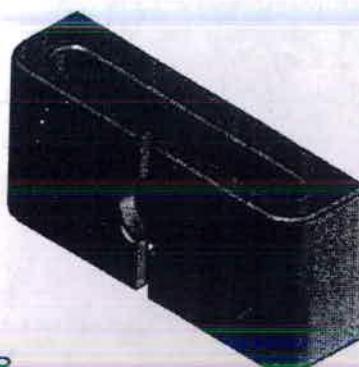
**COPYRIGHT © 2007 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A	SHEET 1 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1	
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE		

**RELEASED**07.04.12 *[Signature]***D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\frac{\pi}{4}$

**COPYRIGHT © 2007 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

